

Work Order ID: 60346

July 6, 2010 11:34:10 AM

Page 1

Item ID: D212-664-207

Revision ID:

Item Name: Crosstube Low Standard Aft

Start Date: 7/06/10 Start Qty: 1.00

Required Date: 7/13/10 Req'd Qty: 1.00

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D212-664-247

Rev B

100



DC

Document Control

0.00

DOCUMENT CONTROL

Memo

Photocopy bluefile and create labels as per PPP D212-664-207 CHG001

0.00

110



Packaging

Packaging

0.00

Pick Kit
Packaging

Memo

0.00

120



CNC Bend 2

CNC Alpha 160 Bender

0.00

BENDING MACHINE - CROSSTUBES

Memo

Bend tube as per Dwg D212-664-247 using CNC bender program and Folio FT

0.00

SCRAP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D212-664-207 PAR #: _____ Fault Category: X - tubes NCR: Yes No DQA: [Signature] Date: 10/07/13
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: [Signature] Date: 10/07/13

NCR: <u>60346</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10-07-13	120	<ul style="list-style-type: none"> Tube Broke while bending. Mandrel is inserted on the inside of the ends of the tube while bending, to reduce the amount of crushing in this area, so the cuffs can be properly installed. Mandrel is slightly long. Process / Tooling. 	<u>[Signature]</u> 10-07-13	<ul style="list-style-type: none"> Slightly shorten the mandrel by 0.250" (1/4") & put a full radius (R) on the end to avoid it pushing out on the tube while bending. Scrap: destroy tube. 	<u>MD</u> 10-07-13		<u>[Signature]</u> 10-07-13	<u>[Signature]</u> 10-07-13

NOTE: Date & initial all entries

Work Order ID 60346

July 6, 2010 11:34:10 AM



Page 2

Item ID: D212-664-207

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Low Standard Aft

Start Date: 7/06/10

Start Qty: 1.00



Cust Item ID:

Required Date: 7/13/10

Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



QC

Quality Control

QC15- Crosstube Dimensional Check

0.00

Memo

0.00

140



Crosstubes

Crosstubes

Crosstubes

0.00

Memo

0.00

1-Drill Rivet holes as per Dwg D212-664-247 using DT8972.***Use T-Pin***

2-Drill pilot holes in tube as per Dwg D212-664-247 using DT8550 and DT8551

3-Ream hole to finish size in tube as per Dwg D212-664-247

4-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-247

5-Scribe part # and batch # using vibrating stylus as per Dwg D212-664-247

SCRAP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60346

July 6, 2010 11:34:11 AM

Page 3

Item ID: D212-664-207

Accept

Revision ID:

Item Name: Crosstube Low Standard Aft

Start Date: 7/06/10 Start Qty: 1.00

Required Date: 7/13/10 Req'd Qty: 1.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

150



HandFXtube

Hand Finishing Crosstubes

Operation
Description

Crosstubes Chemical Conversion

Set Up/
Run Hours

0.00

Memo

0.00

Chemical Conversion Coat Tube & Cuffs

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

SCRAP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60346

July 6, 2010 11:34:11 AM



Page 4

Item ID: D212-664-207

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Low Standard Aft

Start Date: 7/06/10 Start Qty: 1.00



Cust Item ID:

Required Date: 7/13/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180



Outsource2

Outsource process - NDT

Outsource process - NDT per QSI038 4.1

0.00

Memo

0.00

Liquid Penetrant Inspection as per QSI 038

Issue P/O: _____ LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

190



Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

0.00

Packaging

Memo

0.00

Ensure copy of NDT results attached to work order.

200



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Inspect for damage & ensure results are as per Dwg D212-664-207

SCRAP

Work Order ID 60346

July 6, 2010 11:34:11 AM



Page 5

Item ID: D212-664-207

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Low Standard Aft

Start Date: 7/06/10 Start Qty: 1.00



Cust Item ID:

Required Date: 7/13/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210



Crosstubes

Crosstubes

Crosstubes

Memo

0.00

1-Rivet and assemble Cuffs with T-Pin in the through bolt holes as per Dwg D212-664-247. with Sika flex in Between tube & Cuff

A/R SIKAFLEX -241/-291 BATCH: _____

215



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Inspect cuff with T-Pin

SCRAP

Work Order ID 60346

July 6, 2010 11:34:18 AM



Page 6

Item ID: D212-664-207

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Low Standard Aft

Start Date: 7/06/10 Start Qty: 1.00



Cust Item ID:

Required Date: 7/13/10 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220



SprayPaint

Spray Painting

Spray Painting per QSI005 4.2
SprayPaint

0.00

Memo

0.00

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

PRIME:

Start Time: _____

Finish Time: _____

PAINT:

Start Time: _____

Finish Time: _____

230



QC

Quality Control

QC14- Inspect Spray Paint

0.00

Memo

0.00

Wrap in plastic bag to protect from scratches

SCRAP

Work Order ID 60346

July 6, 2010 11:34:18 AM



Page 7

Item ID: D212-664-207

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Low Standard Aft

Start Date: 7/06/10 Start Qty: 1.00



Cust Item ID:

Required Date: 7/13/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

240



Crosstubes

Crosstubes

Crosstubes

Memo

0.00

0.00

1- Assemble as per Dwg D212-664-247

2- Lightly scuff the bonded area using a 320 grit sand paper and clean the area with 41058 wash 'n' wipe

3- Instal support with magnobond 6398 per dwg D212-664-247, cure for 12hrs before packaging.

Time & date of application: _____

Batch: _____

EXP. DATE _____

250



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

SCRAP

Work Order ID 60346

July 6, 2010 11:34:24 AM



Page 8

Item ID: D212-664-207

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Low Standard Aft

Start Date: 7/06/10 Start Qty: 1.00



Cust Item ID:

Required Date: 7/13/10 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

255



Packaging

Pick Kit

0.00

Memo

0.00

Packaging

260



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

Memo

0.00

270



Packaging

Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPP D212-664-207

SCRAP

Work Order ID 60346

July 6, 2010 11:34:24 AM



Page 9

Item ID: D212-664-207

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Low Standard Aft

Start Date: 7/06/10 Start Qty: 1.00



Cust Item ID:

Required Date: 7/13/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

SCRAP

mf
10-8-06

Picklist Print

July 6, 2010 11:34:07 AM

Page 1

Work Order ID: 60346

Parent Item: D212-664-207

Parent Item Name: Crosstube Low Standard Aft

Start Date: 7/06/10

Required Date: 7/13/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 07.09.12 EC verified by: JLM
 IPP Rev:B ECN 1100p 08-01-11 DD verified by: EC
 IPP Rev:C ECN 1121 08-02-25 DD verified by: eC
 IPP Rev: D QC5 replaced by QC15 at step 5 KJ Verified by: ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D212-664-207TRN

Manufactured

No

110

Each

2.0000

1

1



Crosstube Turning Detail

Location

Loc Qty

Loc Code

LG

2

56629

1

56783

1

D3660-1

Manufactured

No

140

Each

10.0000

2

2



CUFF

Location

Loc Qty

Loc Code

ST477

10

53501

10

CR3212-4-06

Purchased

No

220

Each

1,441,000

44

44



CHERRY RIVET

Location

Loc Qty

Loc Code

ST311

1441

112492

156

112612

285

112724

200

112794

800

~~IX~~ MB 10-07-12

SCRAP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July 6, 2010 11:34:07 AM

Page 2

Work Order ID: 60346

Parent Item: D212-664-207

Parent Item Name: Crosstube Low Standard Aft

Start Date: 7/06/10

Required Date: 7/13/10

Start Qty: 1.00

Required Qty: 1.00

D3595-063-530

Manufactured No

240

Each

117.0000

4

4



RUBBER CUSHION



Location

Loc Qty

Loc Code

FP

80

50030

12

51776

68

LG

37

59581

37

D2940-1

Manufactured No

240

Each

33.0000

2

2



Support



Location

Loc Qty

Loc Code

LG

33

45203

1

47748

12

57338

20

MS21920-28

Purchased No

240

Each

123.0000

4

4



Clamp(per MIL-DTL-8783C)



Location

Loc Qty

Loc Code

FG

5

105884

5

LG

118

112863

26

114749

92

SCRAP

July 6, 2010 11:34:07 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July 6, 2010 11:34:07 AM

Page 3

Work Order ID: 60346

Parent Item: D212-664-207

Parent Item Name: Crosstube Low Standard Aft

Start Date: 7/06/10

Required Date: 7/13/10

Start Qty: 1.00

Required Qty: 1.00

D3428-1 Manufactured No 255 Each 10.0000 1 1
Placard

Location Loc Qty Loc Code

ST056 10
60133 10

MS21042L6 Purchased No 255 Each 216.0000 6 6
Nut

Location Loc Qty Loc Code

ST300 216
111578 16
114495 200

AN960JD616 NAS1149D0663J Purchased No 255 Each 0.0000 18 18
Washer

AN6-40A Purchased No 255 Each 75.0000 4 4
Bolt

Location Loc Qty Loc Code

ST343 75
112828 25
114283 50

AN6-41A Purchased No 255 Each 56.0000 2 2
Bolt

Location Loc Qty Loc Code

ST344 56
112805 6
113288 50

SCRAP

July 6, 2010 11:34:07 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Item	Qty -247	Qty -247B	Part Number	Description
1	X		D212-664-247	CROSSTUBE ASSEMBLY (205/212 LOW AFT)
2		X	D212-664-247B	CROSSTUBE ASSEMBLY (214 LOW AFT)
3	1	1	D6008-132	CROSSTUBE
4	2	2	D2940-1	SUPPORT
5	4	4	D3595-063-530	RUBBER CUSHION
6	2	2	D3660-1	CUFF
7	4	4	MS21920-28	CLAMP (OR MS21920-30)
8	44	44	CR3212-4-06	RIVET (OR M7885/3-4-06)
9	A/R	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
10	A/R	A/R	SIKAFLEX-241/-291	SEALANT (OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT)

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6008-132
FINISHED LENGTH = 128.258±0.020 (BEFORE BENDING/TRIMMING)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D212-664-XXX" AND BATCH NUMBER ON INSIDE OF CUFF
USING VIBRATING STYLUS.
- 7) WEIGHT: D212-664-247 = 36.6 lbs (PER IIN-D212-664)
D212-664-247B = 36.6 lbs (PER IIN-D212-664)
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) WHEN MACHINING TAPER, RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD
BE SMOOTH
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6%
BASED ON O.D. EXCEPT UP TO 10% IS ALLOWED IN AREA NOTED.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2940-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF
D2940-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER
INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-28 CLAMPS (OR -30) WITH D3595-063-530 RUBBER CUSHIONS TO SECURE THE D2940-1
SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE
SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.
DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE
UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS
NOT BOTTOMED-OUT AFTER TORQUING.
- 16) INSTALL D3660-1 CUFF AFTER CHEMICAL CONVERSION COAT BUT BEFORE PAINT, WITH A LAYER OF
SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT BETWEEN CUFF AND CROSSTUBE.
SEAL EDGE OF CUFF TO ENSURE NO GAPS.
- 17) TOUCH-UP HOLES WITH CHEMICAL CONVERSION COAT.

SCRAP

RELEASED
2009-10-7 9

B	REVISE GENERAL NOTES/PART LIST; UPDATE TO CURRENT STANDARDS; ADD -247B (ZN C4-2, D5-2)	RF	09.09.30
A	NEW ISSUE	CP	07.07.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D212-664-247	SHEET 1 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CROSSTUBE (205/212 LOW AFT)	NTS
DATE	09.09.30	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

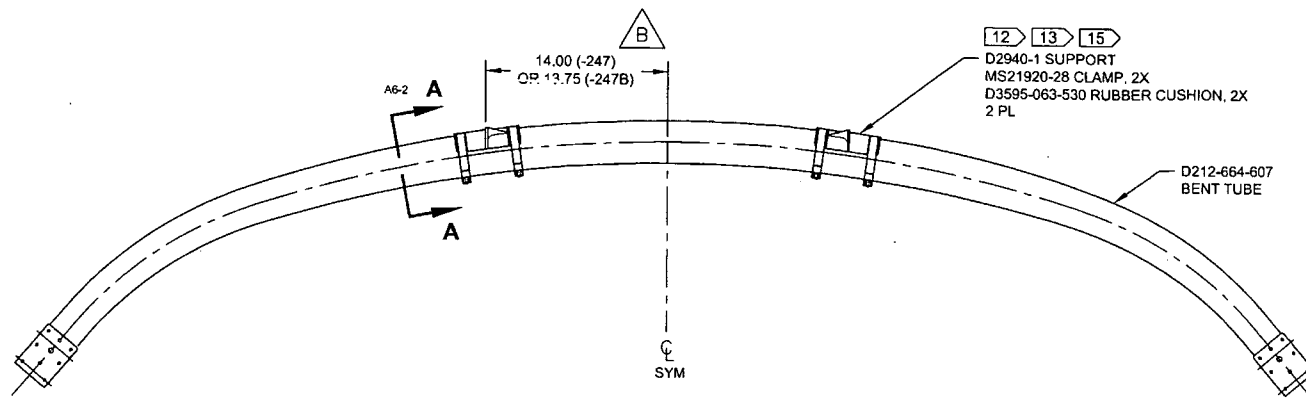
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

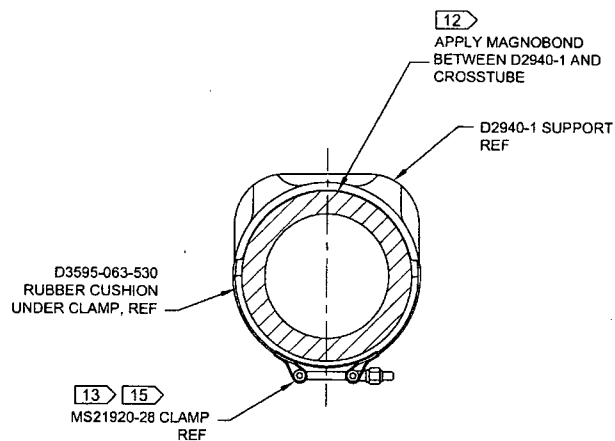
SCRAP



**D212-664-247/-247B
ASSEMBLY DETAIL**

B

60346



SECTION A-A D6-2
SCALE 4X

RELEASED
2009-10-29

DESIGN	97	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	97	DRAWING NO.	REV. B
MFG. APPR.	SS	D212-664-247	SHEET 2 OF 4
APPROVED	AP	TITLE	SCALE
DE APPR.	4	CROSSTUBE (205/212 LOW AFT)	NTS
DATE	09.09.30	<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

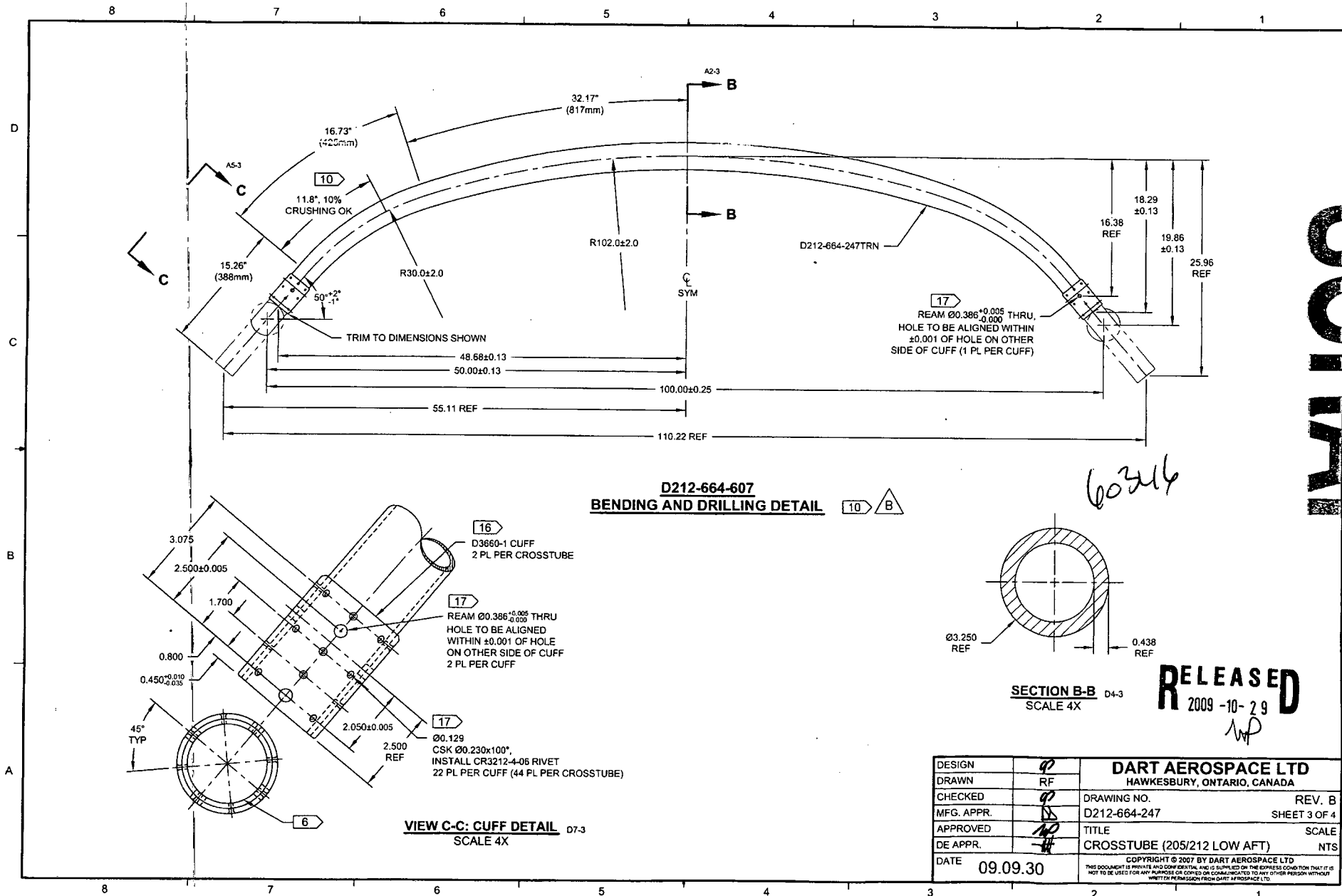
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



SCRAIP

Dart Aerospace Ltd

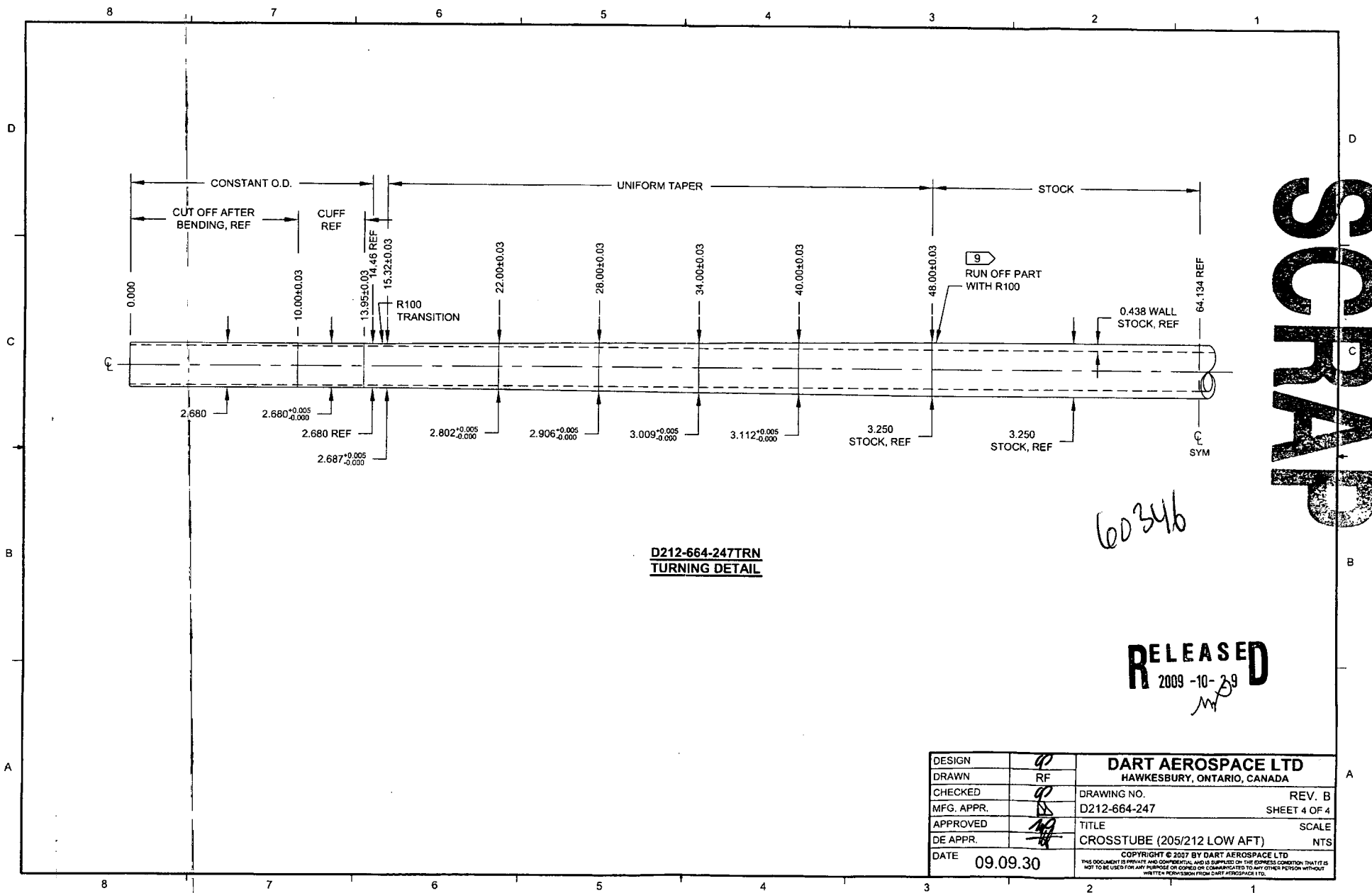
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**D212-664-247TRN
TURNING DETAIL**

RELEASED
2009-10-29
My

DESIGN	90	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	90	DRAWING NO.	REV. B
MFG. APPR.	18	D212-664-247	SHEET 4 OF 4
APPROVED	18	TITLE	SCALE
DE APPR.	18	CROSSTUBE (205/212 LOW AFT)	NTS
DATE	09.09.30	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

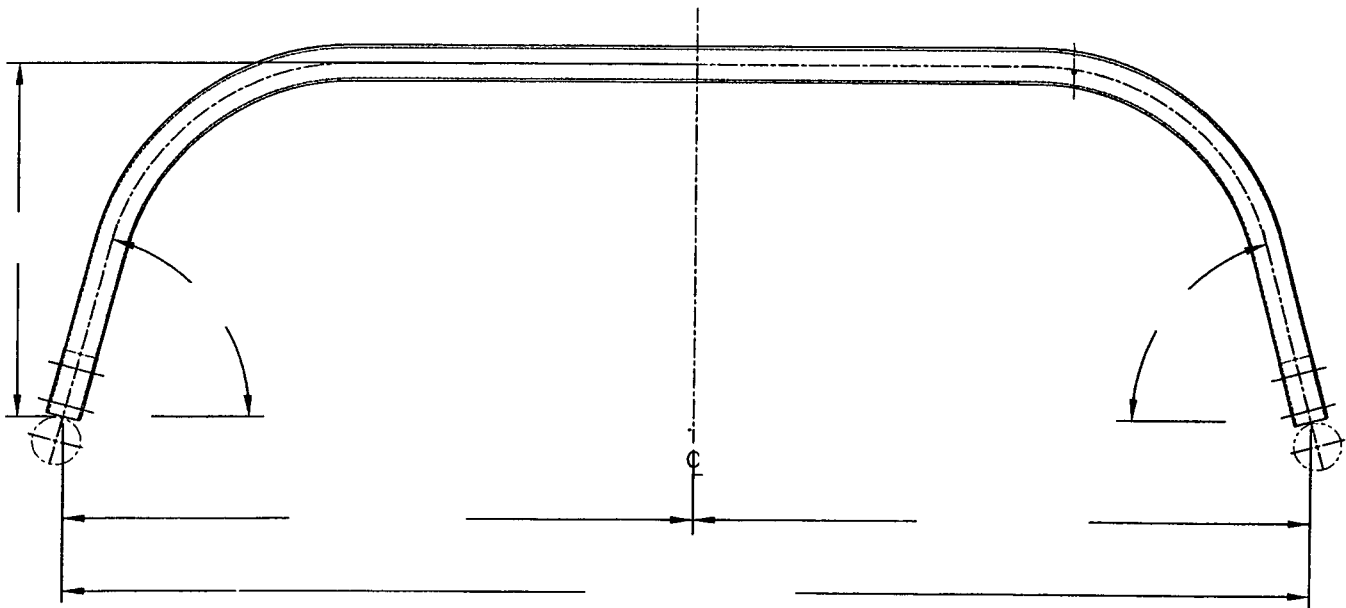
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 50346
Description: Crosstube Low Aft (205/212)		Part Number: D212-664-207
Inspection Dwg: D212-664-247 Rev: B		Page 1 of 1

Required Dimension	Min	Max
Height	18.16	18.42
1/2 Span	48.55	48.81
Angle	49	52
Total Span	97.1	97.62



Comments

QC15 Inspection	
Date	

Rev	Date	Change	Revised by	Approved
A	08.02.29	New Issue	KJ/JM	
B	10.04.01	Dwg Rev updated	KJ	

SCRAP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries